| Date: Wedn | nesday, 6/6/2007 2:02:51 PM | | | - |
|--|---|--|--|-------------|
| 0301. | Pro | cess Sheet | • | |
| Customer Job Number Estimate Number P.O. Number This Issue Prsht Rev. First Issue Previous Run Written By Checked & Approv Comment | : CU-DAR001 Dart Helicopters Services : 32816B : 10304 : NA : 6/6/2007 S.O. No. : NO : NC : 1000 Type : MACHINED PARTS : 32272B : MACHINED PARTS : Strev.B 07.05.29 Thermoform in-hou | Part Number Drawing Number Project Number Drawing Revision Material Due Date | : WINDOW ASSEMBLY : D3136043 : D3136 REV D : N/A : D : N/A : D : N/A : D : N/A : D Oty: | 8 Um: Each |
| Additional Product | | | | |
| | | | | |
| Job Number: | | | | |
| Seq. #: | Machine Or Operation: | Description : | | |
| 1.0 | MACRLICS125 1/8" P | olycast II Sheet | | |
| Comme | ent: Qty.: 3.9000 sf(s)/Unit Total: 31.2000 sf(| s) + M104596 | (z) | |
| 2.0 | <u> </u> | WATER JET B M 07 06 20 | | (5) |
| | ent: FLOW WATER JET | | 5 /24 | |
| 3.0 | BAM O | CT PARTS AS THEY COME O | PER MACHINE | (8) |
| 4.0 | ent: INSPECT PARTS AS THEY COME OFF MACHII | ND CHECK | | |
| | | | | (aute) |
| | ent: SECOND CHECK | MOEODMINO MACHINE | in or | do 6/27 (+2 |
| 5.0 | THERMOFORMING THER | MOFORMING MACHINE | | |
| Comme | ent: 1-Thermoform as per Dwg .D3136 and Folio FTA Dwg. Rev Folio Rev. FTA 003_ | A002 | 07/07 | 106 Hr. |
| | 2- Engrave Part # and Batch # , and affix labels | नावरी ७५ | Il. | |
| | | | | |

| W/O: | | WORK ORDER CHANGES | ORDER CHANGES | | | | | | |
|------|----------|--------------------|---------------|------|----------|-------------------------------------|--------------------------|--|--|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | |
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| Part No: | PAR #: | Fault Category: | NCR: Yes (No) DQA: | Date: (Horlos |
|----------|--------|-----------------|--------------------|---------------|
| | | | QA: N/C Closed: | Date: |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | |
|------|------|----------------------------------|----------------------|------------------------------|----------------|--------------|-----------------------|--------------------------|--|--|
| | | STED Description of NC | | Corrective Action Section E | 3 | Verification | Annroyal | Annessal | | |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Approval Chief Eng | Approval QC Inspector | | |
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NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 2:02:51 PM User: Kim Johnston **Process Sheet** Drawing Name: WINDOW ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Job Number: 32816B Part Number: D3136043 Job Number: Description: Seq. #: **Machine Or Operation:** 6.0 D31089 Decal Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s) Pick: 07/07/06 Dh. Qty Part# Description Batch B27608 D3108-9 Decal INSPECT PARTS AS THEY COME OFF MACHINE 7.0 QC2 07/07/04/04. Comment: INSPECT PARTS AS THEY COME OFF MACHINE INSPECT WORK TO CURRENT STEP 8.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 QC21 DONONOS Comment: FINAL INSPECTION/W/O RELEASE (207/07/09 Job Completion

| Dart Ae | rospace Li | td | | | | | | | |
|---------|------------|---|---------------------|----------|--------|---------------|-------|-------------------------------|--------------------------|
| W/O: | | | WORK ORDER (| CHANGES | | | | | |
| DATE | STEP | PRO | OCEDURE CHANGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | : | PAR #: | Fault Category: | NCI | R: Yes | No DQA | : | _ Date: _ | |
| | | | | | QA: N | /C Closed | : | _ Date: _ | |
| NCR: | | V | VORK ORDER NON-CON | FORMANCE | (NCR |) | | | |
| DATE | STEP | Description of NC | Corrective Action | | | Verifica | ation | Approval | Approval |
| DAIL | JOIEF | _ · · · · · · · · · · · · · · · · · · · | Initial Action Dece | wintian | Sian & | 1 | 1 | (- p | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|------------------------------|----------------|--------------|-----------------------|--------------------------|--|
| | | Description of NC | | Corrective Action Section B | | Verification | Annroyal | | |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | Approval Chief Eng | Approval QC Inspector | |
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NOTE: Date & initial all entries



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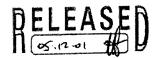
| , | DESIG | * # | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
|---|--------------------|------|--|---|
| | CHECKED # APPROVED | | APPROVED, | DRAWING NO. REV. D |
| | | 献 | # | D3136 SHEET 1 OF 2 |
| | DATE | | ************************************** | TITLE SCALE |
| | 05.1 | 2.01 | | WINDOW ASSEMBLY 1:8 |
| | Α | | 02.04.18 | NEW ISSUE |
| | В | | 04.01.21 | ADDED D3136-3 AND D3136-043 |
| | C | | 04.05.05 | ADDED FORMING & ENGRAVING SPEC |
| | ٥ | | 05.12.01 | UPDATED MATERIAL NOTES |

TO MAXIMUM DEPTH OF 0.005"

SHOP COPY REM'RN TO

NO

EXPREERING



0.80 (REF) 3M MASKING FILM THIS SIDE ONLY R3.70 (TYP) 27.50 · 0.125 (REF) R140 22.63 (REF) 3.70 (2 PLCS) 0.064 R0.06 2.25 (TYP) (4 PLCS) 0.58 0.064 3.70 (2 PLCS) D3108-9 DECAL INSTALLED ON INSIDE - R3.64 (REF) CORNERS OF WINDOW ENGRAVE P/N D3136-041 (2 PLCS) AND B/N ON LOWER EDGE D3136-1 WINDOW D3136-041 WINDOW ASSEMBLY USE 0.125" HIGH LETTERS

NOTES:

1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET FER MIL-P-5425 OR PLEXIGLAS G UNCONTROLLED COPY CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK

2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F

c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS SUBJECT TO AMENDMENT d) TRIM PER TEMPLATE D3136-117

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

(INCLUDES D3108-9 DECALS)

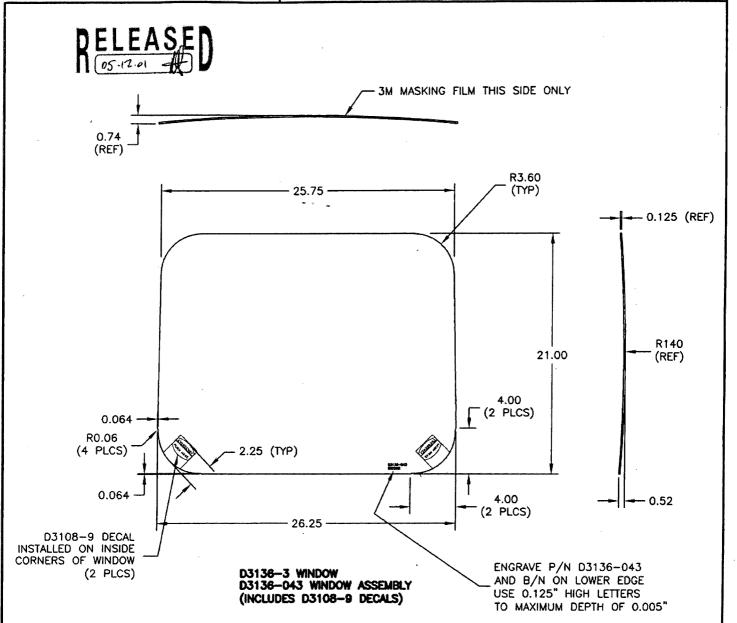
4) ALL DIMENSIONS ARE IN INCHES

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| DESIGN | DRAWN BY | DART AEROSP HAWKESBURY, ONTARI | |
|----------|-----------|-----------------------------------|------------------------|
| CHECKED | APPROVED. | DRAWING NO. D3136 | REV. D SHEET 2 OF 2 |
| DATE | | TITLE | SCALE |
| 05.12.01 | | WINDOW ASSEMBLY | 1:8 |



NOTES:

1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET FER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK

2) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F

b) DRAPE OVER D3136-T1 MOLD & CLAMP

c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

d) TRIM PER TEMPLATE D3136-3T1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY VETURN TO ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDM WITHOUT NOTIC

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| DART AEROSPACE LTD | Work Order: 32816B |
|------------------------------|------------------------|
| Description: Window Assembly | Part Number: 03/36~043 |
| Inspection Dwg: D3/26 Rev: D | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| | | X First Artic | le | Prote | otype | | |
|----------------------|-------------|---------------------|-----------|-------------|----------------------|------------|--|
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | | mments |
| 25.75 | +/- 0.030 | 25.75 | $\sqrt{}$ | | MT | | |
| 21.00 | +1-0.030 | 21.00 | 1/ | | MIT | | |
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| Measured by: | IB MM | Audited by: | En | P | rototype Ap | oproval: | |
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| sicu Date | Manufacture | | | | | K I/II M | |

KJ/JLM

New Issue